

Work Order ID 126403

November-06-14 11:35:29 AM

126403

Page 1

Item ID: D3562-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment
 Start Date: 11/06/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/28/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3562	F								

100 Large Fab 0.00

100

Large Fab

Large Fab

Memo

1-Cut D2622 extrusion as per Dwg D3562
 2-Deburr and bevel ends for welding

0.00

DD 15-5-25

110 QC6- Inspect dimensions to drawing 0.00

110

QC

Quality Control

Memo

0.00

5/1

DAS
49
 9-89

120 Chemical Conversion Coat per QSI005 4.1 0.00

120

HandFinish

Hand Finishing

Memo

0.00

4 15-5-27

15/05/25

Doc

Work Order ID 126403

November-06-14 11:35:29 AM

126403

Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 18 9-09
130	QC7-Inspect Chemical Conversion Coat	0.00								
130										
QC	Memo	0.00				4	0	15-05-27		
Quality Control										

140

140

Small Fab

Small Fab

Small Fab

Memo

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Scotch-Weld as per dwg D3562.

*****Ensure to wipe off any excess magnobond *****

A/R Scotch-Weld DP460

Batch: 01131539

EXP DATE: 15-2-16

DP 15-6-3

DP 15-6-5

Work Order ID 126403

126403

November-06-14 11:35:29 AM

Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									DAS
QC	Memo	0.00							9
Quality Control									9-89
160		0.00							
160	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/RAluminum Rod <i>m130137</i> 2-Grind end cap welds flush as per Dwg D3562								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									DAS
QC	Memo	0.00							9
Quality Control									9-89

④ 15-06-09

4 BK 15-06-09

④ 15-06-09

Work Order ID 126403

November-06-14 11:35:29 AM

126403

Page 4

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									DAS
QC	Memo	0.00							9
Quality Control									9-89
190	Chemical Conversion Coat per QSI005 4.1	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing									
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:10 OVEN TEMPERATURE: 300° FINISH TIME: 11:40								

④ 15-06-09

4 15-6-9 JH

4 15-6-10. DAS 9-89

Work Order ID 126403

November-06-14 11:35:29 AM

126403

Page 5

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>141326380</u> Memo	0.00				<u>X4</u>	<u>0</u>	<u>10</u>	<u>15/06/10</u>
220 *220* QC Quality Control	QC3- Inspect Part Finish Memo	0.00				<u>4X</u>			<u>15/06/11</u> DAS 36 9-89
230 *230* Packaging Packaging	Identify as per dwg & Stock Location <u>C-A</u> Memo <u>w/o 126402</u>	0.00				<u>4X</u>			<u>15/06/11</u> DAS 36 9-89

Work Order ID 126403

November-06-14 11:35:29 AM

126403

Page 6

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

MLJ JUN 16 2015

MLJ JUN 16 2015

Picklist Print

November-06-14 11:35:28 AM

Page 1

Work Order ID: 126403

126403

Parent Item: D3562-042

D3562-042

Parent Item Name: Step Weldment

Start Date: 11/06/14

Required Date: 11/28/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC
IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E
13.06.03 PER DWG REV.F DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

100

Each

42.0000

1

4

D2622-120C

Step Extrusion

**

Location

Loc Qty

Loc Code

HALL

38

109575

32

119621

6

WA003

4

101765

1

115141

3

D2734

Manufactured No

140

Each

75.0000

2

8

D2734

Step End Plate

**

Location

Loc Qty

Loc Code

WA003

75

119286

3

119498

11

124317

60

99709

1

D3560-042

Manufactured No

140

Each

1.0000

1

D3560-042

Arm Weldment

**

Location

Loc Qty

Loc Code

WA003

1

108848

1

124361

15-5-25

BE 15-06-08
B130457 x 1
B130983 x 7

15-6-4

4

Picklist Print

November-06-14 11:35:28 AM

Page 2

Work Order ID: 126403

126403

Parent Item: D3562-042

D3562-042

Parent Item Name: Step Weldment

Start Date: 11/06/14

Required Date: 11/28/14

Start Qty: 4.00

Required Qty: 4.00

D3560-044

Manufactured No

140

Each

1.0000

1

4

D3560-044

Arm Weldment

**

DD 15-6-4

Location	Loc Qty	Loc Code
WA003 <i>123985</i>	1	<i>2</i>
<i>121708</i>	1	<i>1</i>
<i>127765</i> 160	Each	<i>12</i> 128

**

DD 15-6-5

MS20600-AD4W5

Purchased

No

MS20600-AD4W5

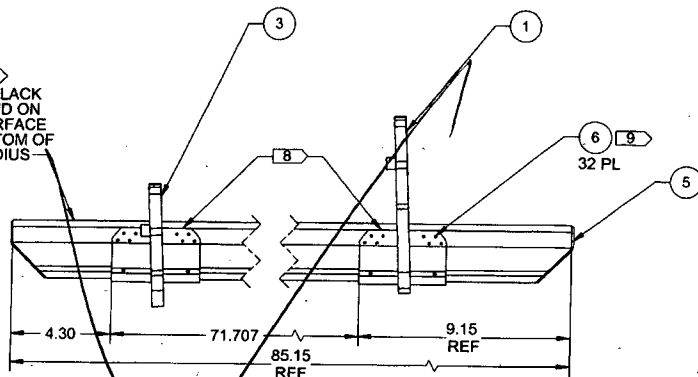
Blind Rivet

Location	Loc Qty	Loc Code
ST308	199	
m129820	149	
m130673	50	
WA003	308	
m129472	308	

131340

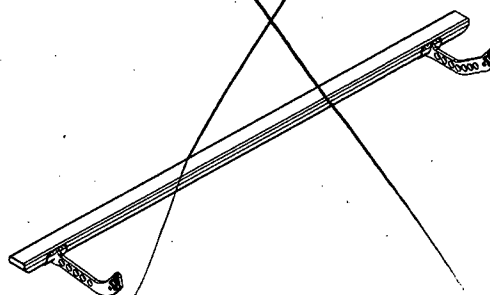
128

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM OF
TOP RADIUS



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD



D3562-041 LH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A

2) FINISH:

- i) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
GREY SANDTEX (4.3.5.6) OR
BLACK SANDTEX (4.3.5.7) OR
GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

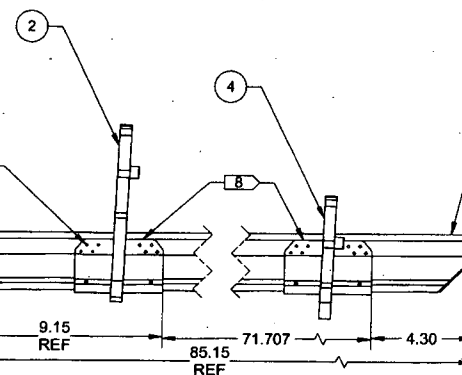
6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.

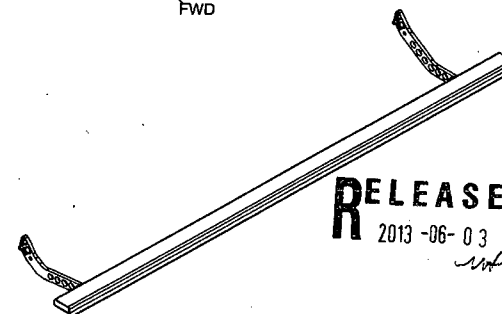
9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING

ITEM No.	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D3562-041	LH STEP ASSEMBLY
		X	D3562-042	RH STEP ASSEMBLY
1	1		D3560-041	ARM WELDMENT
2		1	D3560-042	ARM WELDMENT
3	1		D3560-043	ARM WELDMENT
4		1	D3560-044	ARM WELDMENT
5	1	1	D3562-1	STEP ASSEMBLY
6	32	32	MS20600AD4W5	RIVET



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD



D3562-042 RH STEP ASSEMBLY

F	REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE WITH SCOTCH-WELD DP460, REF. PAR12-224. ADDED NOTE 9 AND SHEET 2	DW	13.05.15
E	ADD QTY(2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAW IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	DW		
CHECKED	GP		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.05.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3562

TITLE
STEP ASSEMBLY

REV. F
SHEET 1 OF 2
SCALE
NTS

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W/O 126403

RELEASED
2013-06-03

8 7 6 5 4 3 2 1

D

D

C

C

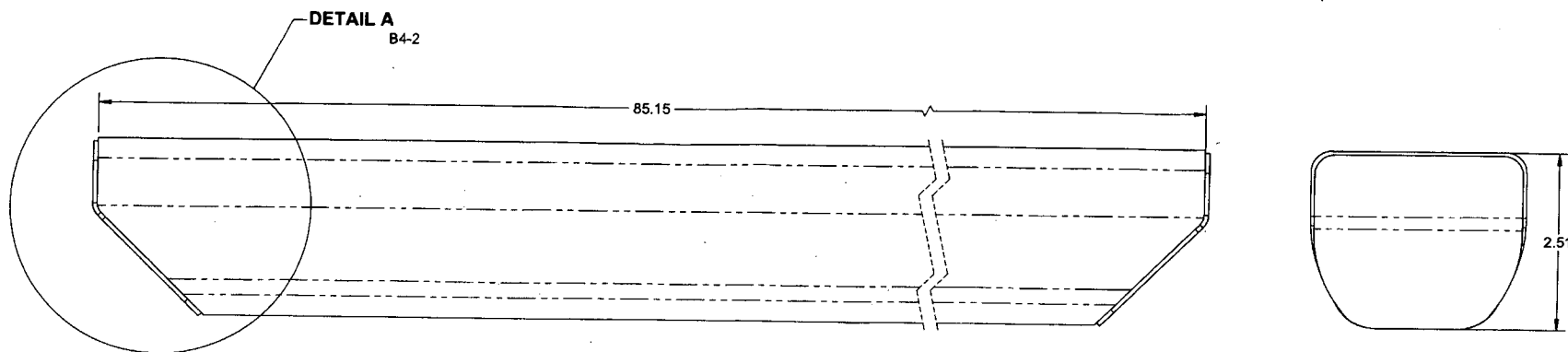
B

B

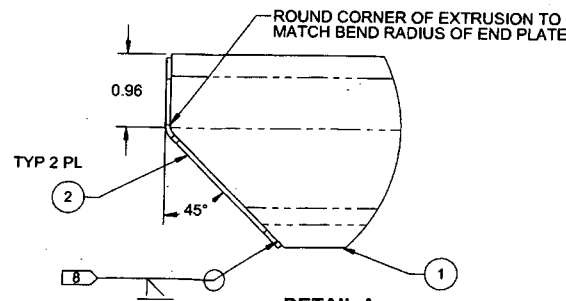
A

A

8 7 6 5 4 3 2 1



D3562-1 STEP ASSEMBLY



DETAIL A
C7-2
TYP BOTH ENDS
SCALE 1X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT STEP EXTRUSION
PER DART QSI 005 4.1 BEFORE ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.68 lbs
- 8) WELDING: ALL WELDS SHALL BE 100% VISUALLY INSPECTED
BY A QUALIFIED INSPECTOR PER DART QSI 004

ITEM No.	QTY	P/N	DESCRIPTION
	-1		
	X	D3562-1	STEP ASSEMBLY
1	A/R	D2622-XXX	STEP EXTRUSION
2	2	D2734	END PLATE

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	CP	D3562	SHEET 2 OF 2
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	STEP ASSEMBLY	NTS
DATE	13.05.15	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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R 2013-06-03
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